

303 R1.000

Work Order ID 80420

February-21-12 9:09:33 AM

80420

Page 1

Item ID: D3638-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bushing

Start Date: 21/02/2012 Start Qty: 24.00

24

Cust Item ID:

Required Date: 06/03/2012 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals:

Process Plan: *M.C.5*Date: *12/02/12* Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3638

Rev B

100

0.00

100

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Machine as per folio FA704Debur and tumble

*24**0**Ref 12/02/12*

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*24**0**Ref 12/02/12*

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*Ref 12/02/12**24**0*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80420

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Item ID: D3638-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bushing
 Start Date: 21/02/2012 Start Qty: 24.00 ***24*** Cust Item ID:
 Required Date: 06/03/2012 Req'd Qty: 24.00 ***24*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <i>ST247</i>	0.00							
130									
Packaging	Memo	0.00							<i>6/27/27</i>
Packaging									<i>(24)</i>
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							<i>12/2/27</i>
Quality Control									<i>(24)</i>

12-02-27
(24)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 80420

80420

Parent Item: D3638-1

D3638-1

Parent Item Name: Bushing

Start Date: 21/02/2012

Required Date: 06/03/2012

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP rev A 07.09.11 new issue EC
IPP Rev:B 08-01-10 ECN 1050 rev.b as per dwg DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R1.000		Purchased		No		100	f	14.0000	0.035	0.884211			
M303R1 000									**	1.300'		12/02/24	

303 Round Bar 1.00

Location

Loc Qty

Loc Code

MAT012

12

120603

12

MAT028

2

120243

2

1.300'

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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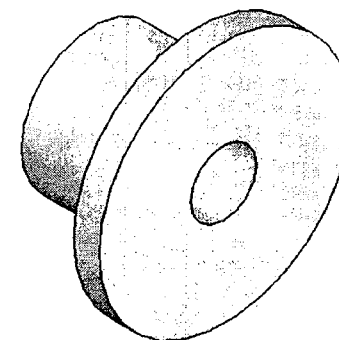
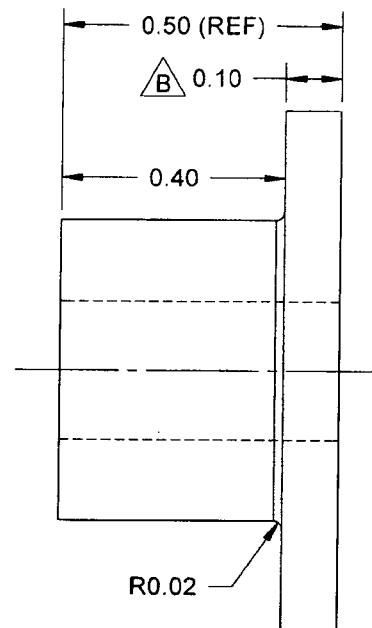
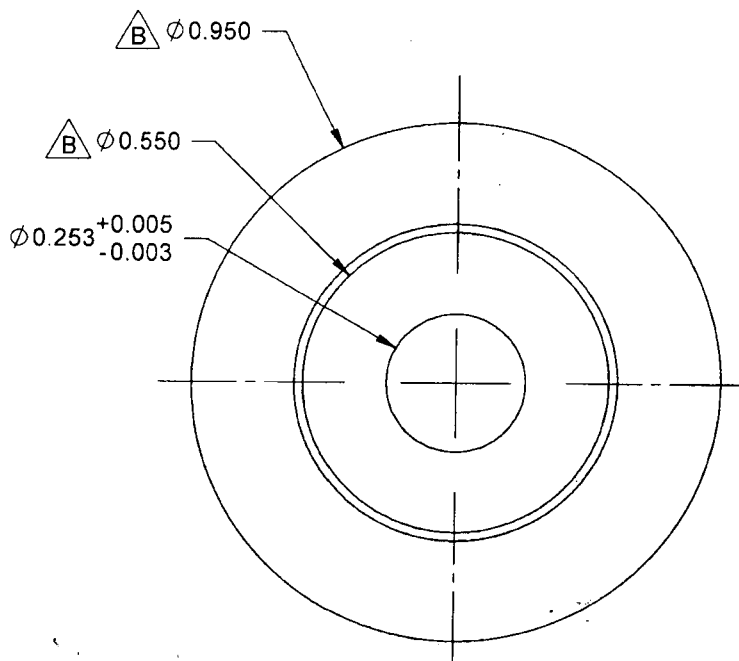
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NOTE: Date & initial all entries



UNCL
SUB

W

NO. 80420 M.L.S.
12/02/21

D3638-1 BUSHING
(REPLACES GENEVA P/N G10608-2)

RELEASED
07.11.14/W

NOTES:

- 1) MATERIAL: AISI 303 ROUND BAR (REF DART SPEC M303R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.01lbs

B	INCREASE SHAFT OD FROM 0.375 TO 0.550; ADD FLANGE	LE	07.10.16
A	NEW ISSUE; REPLACES GENEVA G10608-2	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	LE		
CHECKED	AK	DRAWING NO. REV. B	
MFG. APPR.	ES	D3638 SHEET 1 OF 1	
APPROVED	JP	TITLE SCALE	
DE APPR.	JP	BUSHING 3:1	
DATE	07.10.16	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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